Work Order ID 71599

Wednesday, July 06, 2011 1:28:45 PM

Item ID: D3926-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wedge

Start Date: 7/6/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/20/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** CZ **Date:** 11/07/06 **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3926	Rev A								
100		0.00							
Waterjet	**Memo**	0.00				B11-7-12			
FLOW CNC Waterjet	1-Cut as per Dwg D3926 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-7-12			
Quality Control									

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71599

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00					11	07	12
Quality Control									
130		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr if necessary								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11/07/13 12

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: 104	0.00							
Packaging	Memo	0.00				11/7/13		12	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00					11/7/13		
QC	Memo	0.00							
Quality Control									

MF
11-07-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, July 06, 2011 1:28:42 PM

Work Order ID: 71599

Parent Item: D3926-1

Parent Item Name: Wedge

Start Date: 7/6/2011 **Required Date:** 7/20/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	285.8000	0.3609	3.798947	5.		

#B 11-7-D

Location	Loc Qty	Loc Code
MAT018	285.8	
117321	76.6	
117738	54.3	
117819	154.9	

117819

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	71599
Description: Wedge	**Part Number:**	**D3926-1**
Inspection Dwg: D3926 **Rev:** A		**Page 1 of 1**

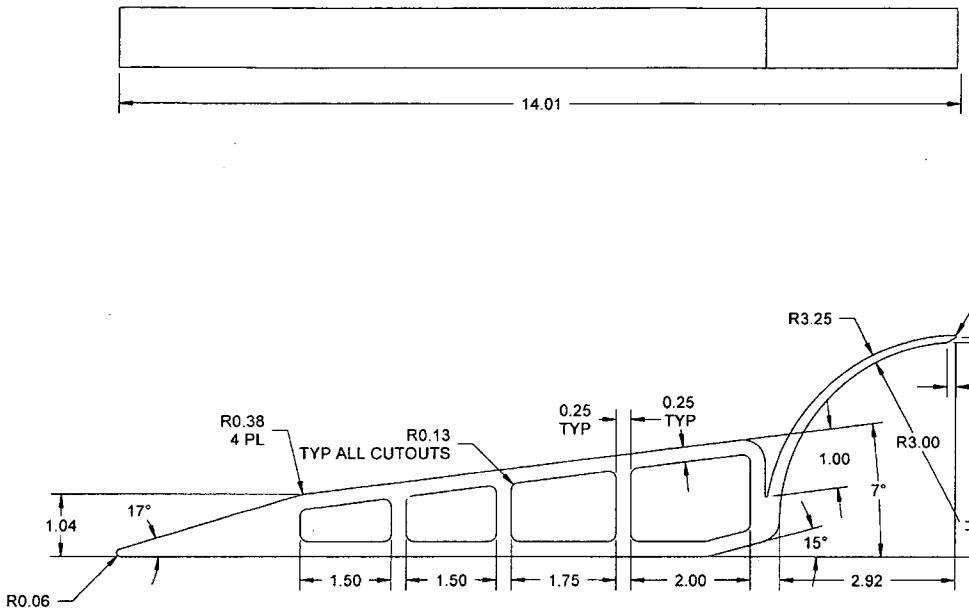
FIRST ARTICLE INSPECTION CHECKLIST

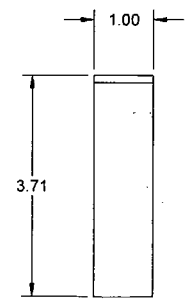
[X] **First Article** [ ] **Prototype**

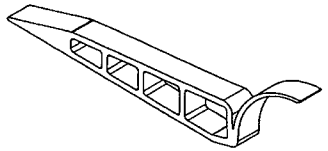
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.036	✓		V IBoz	
1.50	+/-0.030	1.525	✓		V	
1.50	+/-0.030	1.524	✓		V	
1.75	+/-0.030	1.765	✓		V	
2.00	+/-0.030	2.009	✓		V	
2.92	+/-0.030	2.941	✓		V	
1.00	+/-0.030	1.004	✓		V	
0.25	+/-0.030	.241	✓		V	
0.25	+/-0.030	.241	✓		V	
3.71	+/-0.030	3.71	✓		V	
1.00	+/-0.030	.995	✓		V	
14.01	+/-0.030	14.00	✓		T IBoz	

Measured by:	FB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	11-7-12	Date:	11.07.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.17	New Issue	KJ [signature]	[signature]







RELEASED

D3926-1 WEDGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDM...
WITHOUT NOTICE
WORK ORDER
NO. 71599

NOTES:
1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB10
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.07.23

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED	AJS	DRAWING NO. D3926 — REV. A — SHEET 1 OF 2
MFG. APPR.		
APPROVED		TITLE WEDGE — SCALE NTS
DE APPR.		
DATE	09.07.23	

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CZ 11/07/06